

Work Order ID 108806

November-11-13 9:04:09 AM

108806

Page 1

Item ID: D206-642-451

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4361	A
-------	---

IIN-D206-642	P
--------------	---

100

0.00

100

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile and create labels per PPP D206-642-451 CHG001

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tubeas per Dwg D4361								
	3-Weld Fwd Cap as per Dwg D4361. Use aluminum rod. Grind D2647 to fit as required. A/RAluminum Rod <i>m126325/m122324</i>								
	4-Grind weld flush to cap on top surface only.								
	✓5-Cut aft end to lenght from front of tube								
	✓6-Drill pilot holes using drill jig DT8025 & DT8169 A-B-C-D								
	✓8-Open Aft cap hole using # 6 drill bit								
	✓9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-043 Drilling Detail								
	✓10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D4361								
	✓11-Deburr and Blow out all chips form inside the tube								

DC 13/11/11

BE 13/11/12

13-11-12 DGL

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

DAS
9
9-89

13-11-12

116

QC10- Inspect visual per QSI004- ground welds

0.00

116

QC

Memo

0.00

Quality Control

DAS
9
9-89

13-11-12

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

- DC 13/11/18

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Start Date: 10/24/13 Start Qty: 1.00

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Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

130

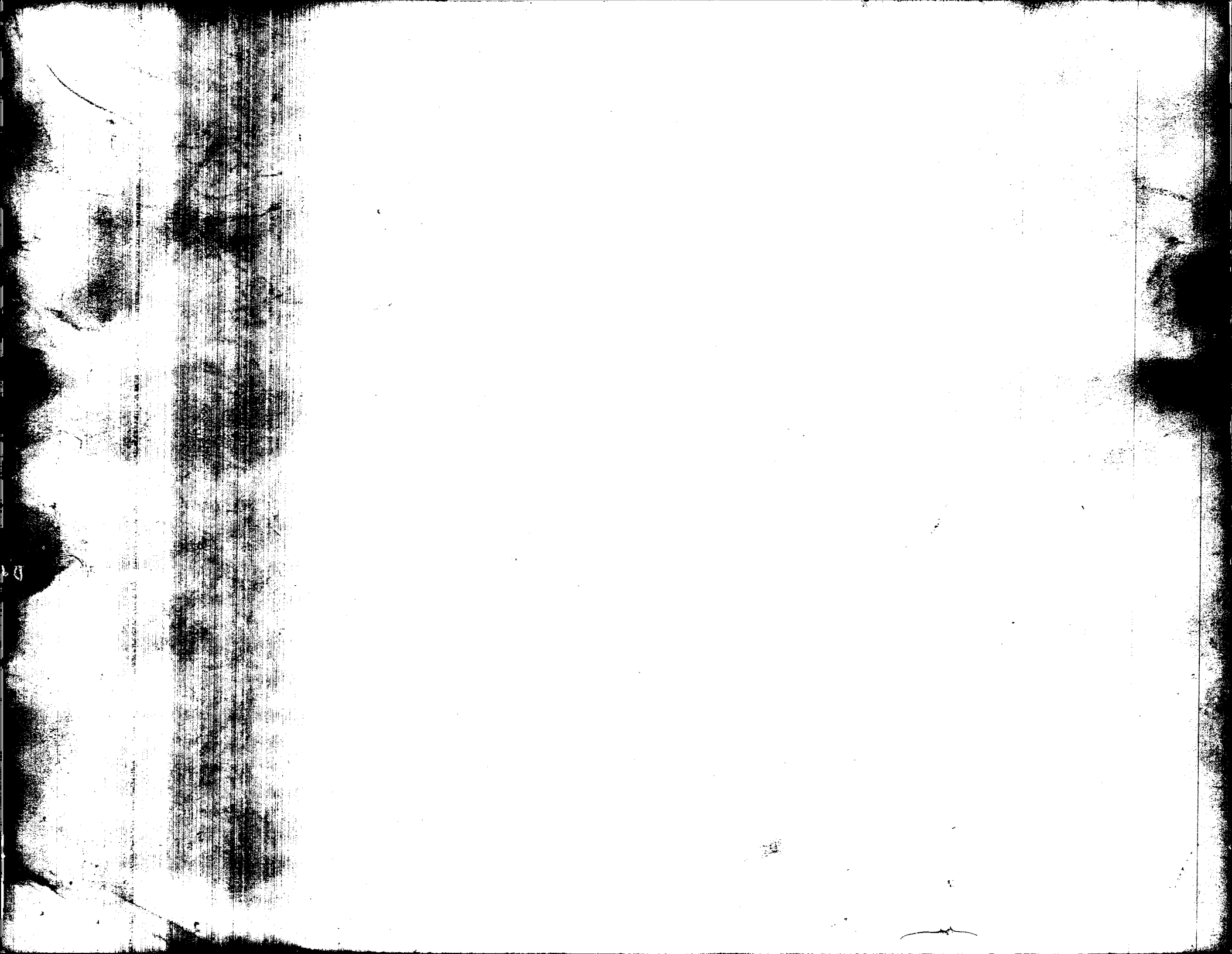
QC

Memo

0.00

Quality Control

DP 13-11-18



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Item ID: D206-642-451

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Stop

NS2

Start Date: 10/24/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D4361, D4361-043 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D4361 (without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 13-11-13

Time: 4:00

Finish Date: 13-11-20

Time: 7:00

A/RSikaflex-291 m127110
Sikaflex expiry date: 14-01-29

BE13-11-13

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

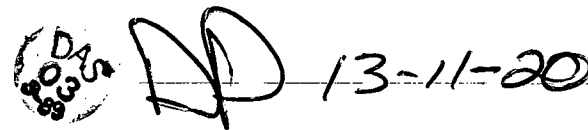
150

QC

Memo

0.00

Quality Control



160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D4361. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod m122324

2-Grind welds flush as per Dwg D4361.

3-Counterbore 5/16" x 0.750" deep as per Dwg D4361. Deburr



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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	HandFinishing								
Skidtubes	Memo	0.00							
Skidtubes	Install D2680-041 Nut Plate as per Dwg D2650								
180									
180	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
190									
190	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

1 0 BE 13-11-20

① 13-11-21 DAS 9 9-89

① 13-11-21 DAS 9 9-89

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

Pressure Wash per QSI005 4.3

0.00

200

Hand Finish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 76 12/1/13

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

210

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:35
OVEN TEMPERATURE: 300°
FINISH TIME: 11:05

1 13122

DAS
34
9-89

220

QC3- Inspect Part Finish

0.00

220

QC

Memo

0.00

Quality Control

1 RA 14/10/14

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Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 1.00 *1*

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearplates as per dwg D4361.								
	2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D4361. Clean excess adhesive								
	3-Install MS27039-4-06 Screw								
	4-Inspect for foreign object per QSI 024								
	5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/RSikaflex-291 <u>AL127093</u> Sikaflex expiry date: <u>10/10/13</u>								
	6-Wing Walk as per Dwg D4361-043 and QSI 005 4.4 Batch: <u>161127625</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

14/1/14

12/11 / 14/10/13

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Required Date: 10/29/13 Req'd Qty: 1.00 *1*

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Packaging	0.00							
250									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-451								
	Location: _____								
	PPP Rev: _____								
260	QC21- Final Inspection - Work Order Release	0.00							
260									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89

14/1/15

PPD 108802

14-01-16

14-01-16

Picklist Print

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Page 1

Work Order ID: 108806

Parent Item: D206-642-451

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-06-13 JLM VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No				Each	24.0000					
Skidtube, 206 Skidtube													

Location	Loc Qty	Loc Code
----------	---------	----------

LG	24	
106240	1	
108384	20	
91134	1	
93646	1	
93647	1	

D2651-1		Manufactured	No				Each	568.0000					
Plug													

Location	Loc Qty	Loc Code
----------	---------	----------

FP	200	
104843	200	
FP001	368	
103305	18	
103858	114	
106456	136	
57869	1	
66445	10	
69018	2	
70827	2	
77559	31	
78124	5	
78584	14	
79234	4	
81954	6	
85456	3	
93664	9	
96854	1	
98156	12	

De 13 1/11/11

0

11/01/14

x 8

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Work Order ID: 108806

Parent Item: D206-642-451

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

D2651-3

Manufactured No

Each 649.0000

O-Ring



Handwritten: *ll x0e 14/01/13*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	326	
104725	126	
104726	200	
FP001	323	
102315	120	
108583	175	
61962	12	
73828	4	
90507	4	
98907	8	

Handwritten: *x08*

D2646

Manufactured No

Each 93.0000

Aft Cap

Handwritten: *ll 1 14/01/13*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	4	
85848	2	
90495	2	
FP001	89	
103306	19	
107857	42	
62678	5	
68280	5	
70945	1	
71070	2	
73294	1	
73825	2	
79562	2	
85443	2	
85848	2	
91189	5	
93661	1	

Handwritten: *x1*

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Work Order ID: 108806

Parent Item: D206-642-451

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

Each

1,327.0000

Screw

U² 11/01/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	1	
117423	1	
ST305	3	
121243	3	
ST506	36	
124326	36	
st507	1283	
m126319	783	
m127255	500	
ST509	4	
125654	4	

X2

NAS1149D0332J

*

Purchased

No

Each

2,993.0000

Washer

U² 11/01/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST293	1607	
125268	7	
m123374	600	
m127431	1000	
ST294	386	
122973	75	
125044	8	
m125807	303	
ST511	1000	
m127389	1000	

X2

D4366-041

Manufactured

No

Each

0.0000

Fwd Wearplate Assembly

B108765(1x) U¹ 11/01/14

D4366-043

Manufactured

No

Each

0.0000

Aft Wearplate Assembly

B108839(1x) U¹ 11/01/14

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Work Order ID: 108806

Parent Item: D206-642-451

Parent Item Name: Replacement Skidtube, High Gear Run-On Landing (Fits LH or RH)

Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

Each 421.0000

Bushing

Location

Loc Qty

Loc Code

FP002

4

B109110

90492

4

ST067

404

104858

84

105611

300

93658

20

ST069

13

91188

11

93659

2

AN3-36A

Purchased

No

Each 163.0000

Bolt

Location

Loc Qty

Loc Code

ST353

163

15072

72

15924

91

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Parent Item: D206-642-451

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Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

13,051.000

WASHER

10 11/01/13

Location Loc Qty Loc Code

FP001	264	
123355	264	
ST292	119	
123248	18	
123759	10	
125268	91	
st510	10776	
m126319	5276	
m127306	2500	
m127410	3000	
ST511	1766	
125654	1766	
ST517	126	
124580	126	

x10

MS21042-3

MS21042L3

Purchased

No

Each

397.0000

Nut

10 11/01/13

Location Loc Qty Loc Code

ST314	397	
123352	11	
123525	386	

~~11124553~~
11124555

x10

D2654-7

Manufactured

No

Each

4.0000

Web

1 11/13-11/18

Location Loc Qty Loc Code

LG	4	
108145	4	

1

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Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

D2647 Manufactured No Each 35.0000

1

BE13-11-12

Location	Loc Qty	Loc Code
LG002	35	
102371	15	
103459	3	
107588	15	
75482	2	

1

D2649 Gross Bolt Spacer Manufactured No Each 590.0000

26

BE13-11-20

Location	Loc Qty	Loc Code
LG	478	
107906	208	
108633	196	
93662	74	
LG001	16	
106886	12	
90967	1	
91191	3	
LG002	96	
82813	40	
85586	4	
86912	3	
88529	15	
90333	7	
90497	6	
93663	21	

26

D2680-041 Nut Plate Manufactured No Each 5.0000

1

BE13-11-20

B108819 x1

Location	Loc Qty	Loc Code
ST014	5	
103551	2	
91162	3	

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Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

Each 351.0000

2

Cherry Rivet

BBB-11-20

Location	Loc Qty	Loc Code
FP001	5	
122973	5	
ST327	346	
124259	14	
m126282	134	
m126333	198	

2

CR3212-4-03

Purchased

No

Each 1,150.0000

2

Cherry Rivet

BBB-11-20

Location	Loc Qty	Loc Code
ST328	1150	
114889	24	
119017	700	
123265	424	
123301	2	

2

MS27039-4-06

Purchased

No

Each 105.0000

Screw

BBB-11-20

Location	Loc Qty	Loc Code
ST307	105	
123355	5	
m126534	100	

Y (

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Start Date: 10/24/13

Required Date: 10/29/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each 2,319.0000

WASHER

2

1 10/24/13

Location

Loc Qty

Loc Code

FP001

2

11177683

122441

2

ST007

24

121912

24

ST294

1547

119097

1

124198

35

124778

83

M127255

1428

ST510a

746

M126221

746

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D4361-041	SKIDTUBE ASSY
	X	D4361-043	SKIDTUBE ASSY
1	1	D2600-1-160	EXTRUSION
1		D2654-5	WEB
	1	D2654-7	WEB
1	1	D2646	AFT CAP
1	1	D2647	CAP
23	26	D2649	CROSS BOLT SPACER
4	8	D2651-1	PLUG
4	8	D2651-3	O-RING
1	1	D2680-041	NUT PLATE
18	20	D3873-1	BUSHING
1		D4364-041	FWD WEARPLATE ASSY
1		D4364-043	AFT WEARPLATE ASSY
	1	D4366-041	FWD WEARPLATE ASSY
	1	D4366-043	AFT WEARPLATE ASSY
9	10	AN3-36A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN960C10L)
9	10	MS21042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	MS27039-1-08	SCREW
1	1	MS27039-4-06	SCREW
1	1	NAS1149D0463J	WASHER (OR AN960JD416)

NOTES:

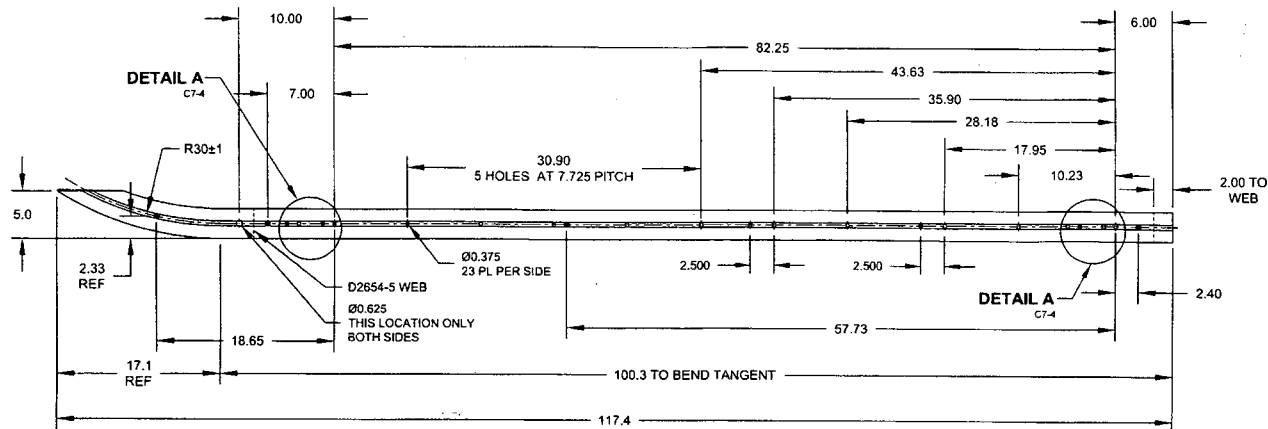
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2654-5/-7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE.
A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

108806 MLJ
13-10-31

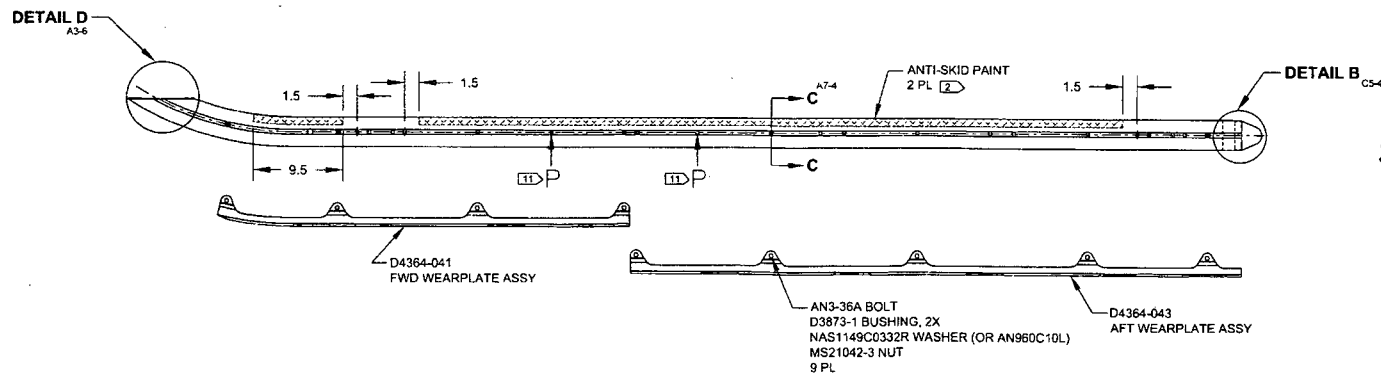
RELEASED
2011-09-12

A	NEW ISSUE	SC	11.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	Q	DRAWING NO.	REV. A
MFG. APPR.	E	D4361	SHEET 1 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	A	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

108806



D4361-041 BENDING/DRILLING DETAIL



D4361-041 ASSEMBLY/FINISHING DETAIL

RELEASED
2011-09-12

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	BE	D4361	SHEET 2 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	#	206L/407 SKIDTUBE ASSEMBLIES	NTS
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DETAIL D
A34

1.5

1.5

C_{AT-4}

ANTI-SKID PAINT
3 PL (2)

1.5

1.5

DETAIL B
C5

23.3

D4366-041
FWD WEARPLATE ASSY

10.0

P

P

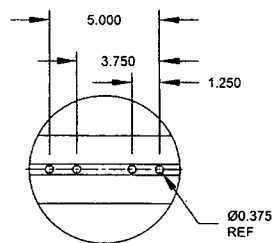
AN3-36A BOLT
D3873-1 BUSHING, 2X
NAS1149C0332R WASHER (OR AN960C10L)
MS21042-3 NUT
10 PL

D4366-043
AFT WEARPLATE ASSY

RELEASE
2011-0

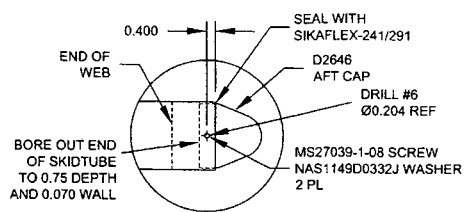
DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>JP</i>	D4361	SHEET 3 OF 3
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	206L/407 SKIDTUBE ASSEMBLIES	
DATE	11.05.05	NT	

108806



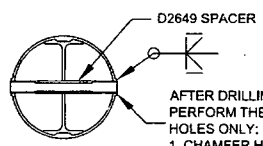
DETAIL A

C3-2
D7-2
C3-3
D6-3



DETAIL B

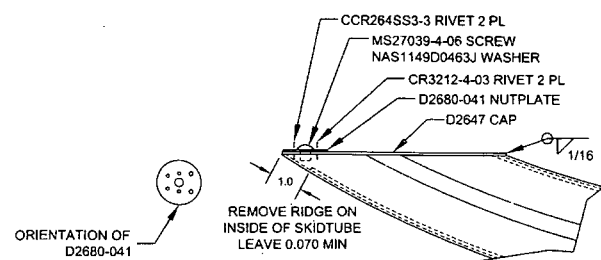
B2-2
B1-3



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP

SECTION C-C
FOR Ø0.375 HOLES
ONLY

B4-2
B5-3



DETAIL D

B7-2
B7-3

DETAIL D NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART OSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
2011-09-12

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	BE	D4361	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	206L/407 SKIDTUBE ASSEMBLIES	NTS
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NO. 325

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: 6101434
Part #: D206-642-541
Description: 220 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Penetration:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Fusion:	pass[<input checked="" type="checkbox"/>]	fail[]
Cracks:	pass[<input checked="" type="checkbox"/>]	fail[]
Overlap (cold lap)	pass[<input checked="" type="checkbox"/>]	fail[]
Undercut:	pass[<input checked="" type="checkbox"/>]	fail[]
Pin holes:	pass[<input checked="" type="checkbox"/>]	fail[]
Porosity (surface):	pass[<input checked="" type="checkbox"/>]	fail[]
Coloration:	pass[<input checked="" type="checkbox"/>]	fail[]
Burn through:	pass[<input checked="" type="checkbox"/>]	fail[]

Qualifier 09 Date of Test Coupon 13-08-02

Welder Barclay Elliott Date of Test Coupon 13-08-02

The above named individual is qualified in accordance with AWS D17.1.2001 to weld